

Work Order ID 109024

November-05-13 11:46:52 AM

109024

Page 1

Item ID: D407-649-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hardpoint

Start Date: 11/05/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-11-05 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

N/A	Rev N/A
-----	---------

**SP*

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file D407-649 and type labels per QSI 014

CHG001

DAS
6
9-89

13/12/14

(1x)

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110

Pick Kit

Packaging

Memo

0.00

Packaging

DAS
26
9-89

13-12-14

1x

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120

QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

DAS
6
9-89

13/12/14

(1x)

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Item ID: D407-649-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hardpoint

Start Date: 11/05/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130				DAS		DAS			
Packaging	Memo	0.00		6		28		13-12-6	
Packaging	Identify and pack for shipping as per PPP D407-649-011 Location: 13-12-6 PPP Rev: C			9-89		9-89			
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

[Signature] 13/12/09

13-12-6

Picklist Print

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Work Order ID: 109024

109024

Parent Item: D407-649-011

D407-649-011

Parent Item Name: Hardpoint

Start Date: 11/05/13

Required Date: 11/19/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B98.12.07Changed location for step 2DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
80-007-15-4A		Purchased	No			120	Each	27.0000	24	24			
80-007-15-4A										**		DAS 26 9-89	DAS 28 9-89
Insert													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST380			27						
					120224		7						
					121500		20						
AN4-6A		Purchased	No			120	Each	1,212.000	24	24			
AN4-6A										**		DAS 26 9-89	DAS 28 9-89
BOLT													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504			1180						
					M126317		1180						
				ST514			32						
					123355		30						
					M126175		2						
D2713		Manufactured	No			120	Each	12.0000	4	4			
D2713										**		DAS 26 9-89	DAS 28 9-89
Hardpoint Lug													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				Mezz			2						
					36699		2						
				ST479			10						
					82667		10						

Picklist Print

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Work Order ID: 109024

109024

Parent Item: D407-649-011

D407-649-011

Parent Item Name: Hardpoint

Start Date: 11/05/13

Required Date: 11/19/13

Start Qty: 1.00

Required Qty: 1.00

D2755-1

Manufactured No

120

Each

12.0000

1 1

**

DAS
26
9-89

DAS
28
9-89

D2755-1

Hardpoint Lug

DAS

3

9-89

Location

Loc Qty

Loc Code

ST479

10

79531

10

ST479a

2

17551

2

D2755-2

Manufactured No

120

Each

13.0000

1 1

**

DAS
26
9-89

DAS
28
9-89

D2755-2

Lug

DAS

6

9-89

Location

Loc Qty

Loc Code

ST479a

13

17552

3

48383

10

Manufactured No

120

Each

10.0000

6 6

**

DAS
26
9-89

DAS
28
9-89

D2756

D2756

Inner Doubler

DAS

6

9-89

Location

Loc Qty

Loc Code

ST018

10

77745

5

82549

5

Manufactured No

120

Each

41.0000

6 6

**

DAS
26
9-89

D2757

D2757

Outer Doubler

DAS

6

9-89

Location

Loc Qty

Loc Code

ST018

41

77079

14

9235

27

DAS
26
9-89

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Shop Packet Print

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Picklist Print

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Work Order ID: 109024

109024

Parent Item: D407-649-011

D407-649-011

Parent Item Name: Hardpoint

Start Date: 11/05/13

Required Date: 11/19/13

Start Qty: 1.00

Required Qty: 1.00

M7885/2-4-1

Purchased

No

120

Each

120.0000

96 96

**

DAS
26
9-89

DAS
28
9-89

M7885/2-4-1

Rivet

DAS
6
9-89

Location

Loc Qty

Loc Code

ST287

120

110267

120

350.0000

126 126

**

DAS
26
9-89

DAS
28
9-89

M7885/3-4-2

Purchased

No

120

Each

350.0000

126 126

**

M7885/3-4-2

Rivet

DAS
6
9-89

Location

Loc Qty

Loc Code

ST287

350

110267

350

2,650.000

24 24

**

DAS
26
9-89

NAS1149D04631

Purchased

No

120

Each

2,650.000

24 24

**

NAS1149D04631

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

2

122441

2

ST007

24

121912

24

ST294

1547

119097

1

124198

35

124778

83

M127255

1428

ST510a

1077

M126221

1077

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Shop Packet Print

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DAS
6
9-89

REFERENCE ONLY

IIN-D407-649

Page 8 of 8

6 PARTS LIST

Qty	Part Number	Description
X	D407-649-011	407 HARDPOINT KIT INSTALLATION
4	D2713	BRACKET
1	D2755-1	AFT BRACKET LH
1	D2755-2	AFT BRACKET RH
6	D2756	INNER DOUBLER
6	D2757	OUTER DOUBLER
96	M7885/2	RIVET
126	M7885/3	RIVET
24	AN4-6A	BOLT
24	AN960JD416	WASHER
24	80007-154A	INSERT - DOME HEAD

7 HARDPOINT LOAD LIMITS (REFERENCE ONLY)

The maximum limit loads on the Hardpoint Kit are 500 lb vertical load and 280 lb radial horizontal load for each individual hardpoint. The radial horizontal and vertical loads may be applied simultaneously. Any equipment attached to the hardpoints **shall not exceed these loads**.

8 CARGO HOOK LIMITATIONS (REFERENCE ONLY)

Loads applied to the Dart Hardpoint Kit Installation will limit the load carrying capacity of the cargo hook according to the following Figure. When the hardpoints are loaded to their maximum capacity, outlined in section 7 of this document, the cargo hook is limited to carrying a maximum load of 1850 lb.

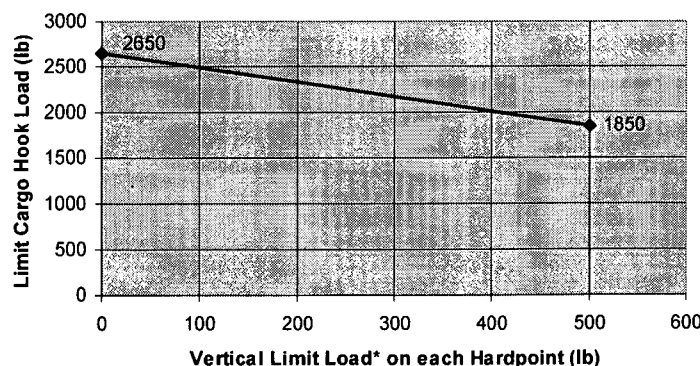


Figure 5 - Cargo Hook Limitations for Hardpoint Loads

* The Vertical Limit Load on each Hardpoint refers to the maximum allowable vertical limit load for a single hardpoint only. The 500 lb vertical limit load indicated in Figure 5 implies a maximum radial horizontal load of 280 lb, according to section 7 of this document. These limit loads should not be exceeded.

Revision : **B**

Date : 98.04.29



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9114	REV. A SHEET 1 OF 1
DATE 98.11.03		TITLE 407 HARDPOINT KIT	SCALE NTS
A	98.11.03	NEW ISSUE	

DAS
6
9-89

REFERENCE ONLY

DART SERVICE INSTRUCTION

AMEND DART INSTALLATION INSTRUCTIONS IIN-D407-649 REV. B

STA: SH98-18
STC: SR00895NY

DETAILS OF THE CHANGES TO THE PARTS LIST ON PAGE 8 OF
INSTALLATION INSTRUCTIONS IIN-D407-649 REV. B ARE OUTLINED BELOW:

CHANGE:

96	M7885/2	RIVET
126	M7885/3	RIVET
24	80-007-15-4A	INSERT - DOME HEAD

TO:

96	M7885/2-4-1	RIVET
126	M7885/3-4-2	RIVET
24	80-007-15-4A or SL3149-4A-15 or K100H4A95-15 or FT5215-12A-15 or FIT7623-4A-15	INSERT - DOME HEAD

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Item ID: D407-649-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hardpoint

Start Date: 11/05/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/19/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-11-05 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr Revision Nbr

N/A Rev N/A

100 0.00

100 DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy blue file D407-649 and type labels per QSI 014 CHG001

110 Pick Kit 0.00

110 0.00

Packaging Memo 0.00

Packaging

120 QC4- 100% Inspect kits for completeness 0.00

120 0.00

QC Memo 0.00

Quality Control

MLS 13-12-02